

Date:  
User:Thursday, 12/7/2006 4:32:28 PM  
Kim Johnston

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	407 BASKET BASE ASSEMBLY
<b>Job Number</b> :	29832A	<b>Part Number</b> :	D2948041
<b>Estimate Number</b> :	10912	<b>Drawing Number</b> :	D2948 REV B
<b>P.O. Number</b> :	N/A	<b>Project Number</b> :	N/A
<b>This Issue</b> :	12/7/2006	<b>Drawing Revision</b> :	B
<b>Prsht Rev.</b> :	NC	<b>Material</b> :	N/A
<b>First Issue</b> :	N/A	<b>Due Date</b> :	12/19/2006
<b>Previous Run</b> :	21174A	<b>Qty:</b>	1 Um: Each
<b>Written By</b> :	[Signature]		
<b>Checked &amp; Approved By</b> :	[Signature] 06 12 07		
<b>Comment</b> :	Est Rev: 04.08.09 Revised Step 1 KJ/JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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Comment: Qty.: 48.9993 f(s)/Unit Total : 48.9993 f(s)

Material: 304/316 SS tube 0.049" wall

(M304TS0.750W.049)

Batch: M19161

50 FT.

5x120"

DP 6-12-13

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
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Comment: LANDING GEAR RESOURCE 1

Cut (2) D2948-5, 3/4" x 3/4" 120" square tubing for bending as per Dwg D2948

DP 6-12-13

3.0	BENDING	BENDING MACHINE
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Comment: BENDING MACHINE

Form D2948-5 as per Dwg D2948 using CNC bending program 407BASB and Folio FT019

DP 6-12-13

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

DP 06-12-14

5.0	D23273	Spacer Bushing
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description

1 D2327-3 Spacer

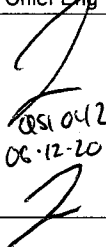
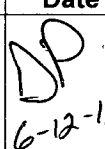

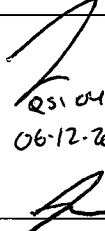
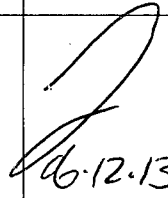
Batch

628597

DP 06-12-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes (No) DQA: FP Date: 06/12/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-12-13	3.0	1x D2948-S over bent in bender.	 QSI 042 06-12-20	re-adjust program for bender. Cut off the mel: us at each end of the mat'l, and I.D. And place back into stock for x-members in the baskets.	 6-12-13	 06-12-13	 QSI 047 06-12-20	 06-12-13

NOTE: Date & initial all entries

Date: Thursday, 12/7/2006 4:32:29 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 BASKET BASE ASSEMBLY

Job Number: 29832A

Part Number: D2948041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description  
2 D2581 Mounting Bracket

Batch

B23915

PD 06-12-18

7.0

D2954

Mounting Plate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description  
4 D2954 Mounting Plate

Batch

D12525

PD 06-12-18

8.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 33.6000 sf(s)/Unit Total : 33.6000 sf(s)

Pick:

Qty Part Number Description  
32sf M304EX0.75-16F SS Expanded Metal

Batch

B1102394

PD 06-12-18

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Trim to length as per Dwg D2948 and DeburrIdentify as D2948-5

2-Cut 3/4" x 3/4" square tubing as per Dwg D2948  
Identify properly as D2948-1/-3/-7/-9

3-Remove all Markings From Material.

4-Weld as per Dwg D2948 and QSI 004. Deburr as required.

A/R SS Rod

Batch: M101744

PD 06-12-18

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

M 06/12/19 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 12/7/2006 4:32:29 PM  
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Drawing Name: 407 BASKET BASE ASSEMBLY

Job Number: 29832A

Part Number: D2948041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*06/12/19* ①

12.0

POWDER COATING

POWDER COATING



*M 102391*



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

*a.m./M-B 06/12/19* ①

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION.

*SAD 06:12/19* ①

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA*

*SB 06/12/19* ①

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

*06/12/20* ①

Job Completion



*u 06-12-20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

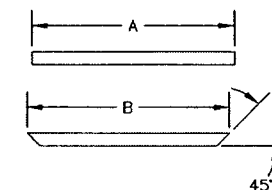
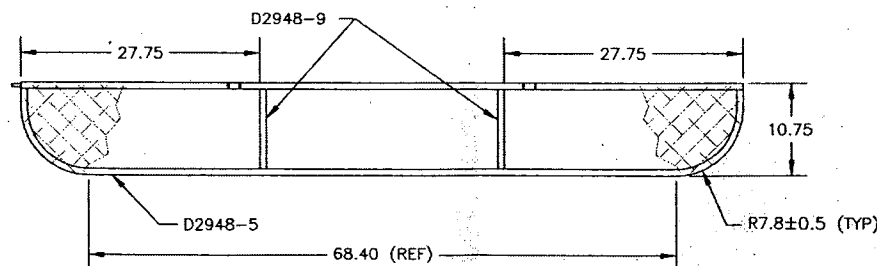
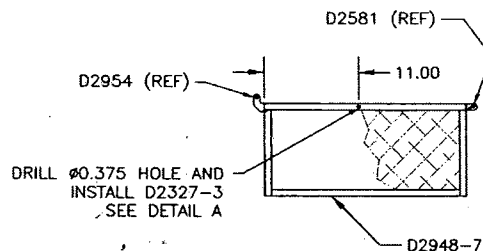
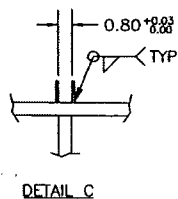
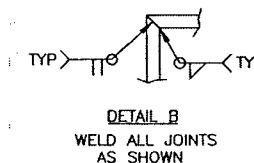
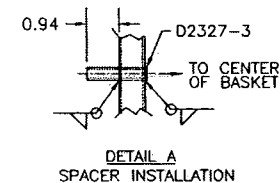
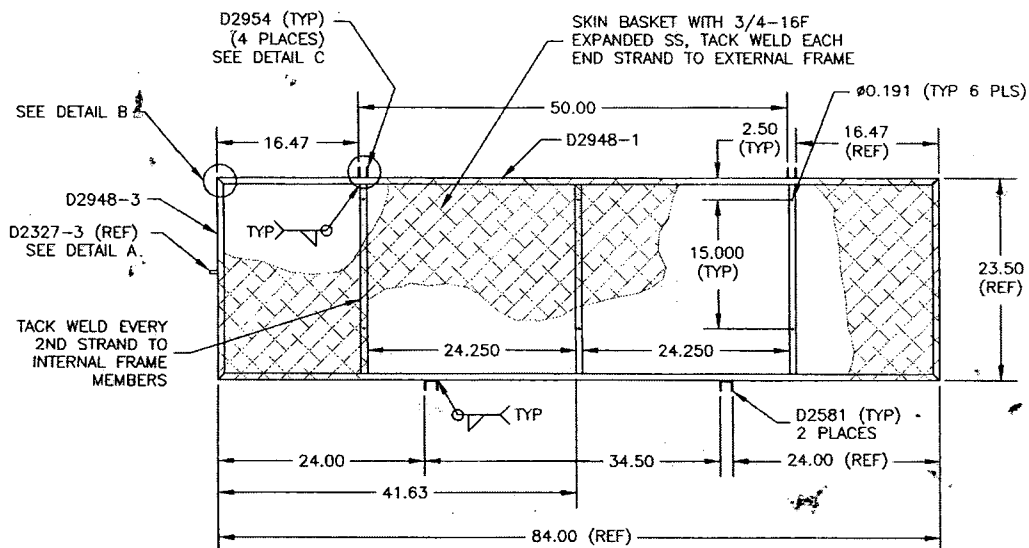
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED  
00.07.18



QTY	PART NUMBER	DESCRIPTION	LENGTH A	LENGTH B
-041				
X	D2948-041	BASKET ASSEMBLY	N/A	N/A
2	D2948-1	FRAME MEMBER	N/A	84.00
2	D2948-3	FRAME MEMBER	N/A	23.50
2	D2948-5	FRAME MEMBER	95.97	N/A
3	D2948-7	FRAME MEMBER	22.00	N/A
4	D2948-9	FRAME MEMBER	9.25	N/A
1	D2327-3	SPACER	N/A	N/A
2	D2581	MTG BRACKET	N/A	N/A
4	D2954	MOUNTING PLATE	N/A	N/A

FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.049 WALL SQUARE TUBING  
MESH MATERIAL: 3/4-16F EXPANDED SS  
FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3  
WELD PER DART QSI 004  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

WORK ORDER NO. 29832A  
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B	00.07.17	ADD 0.191; R7.8 WAS R6.8
A	00.01.12	NEW ISSUE
DESIGN	RF	DRAWN BY
CHECKED	RF	APPROVED
DATE	00.07.17	TITLE
		BASKET BASE ASSEMBLY
		SCALE
		NTS

**DART**

DART AEROSPACE LTD.  
HARRISBURG, ONTARIO, CANADA

DRAWING NO.  
D2948

REV. B  
SHEET 1 OF 1

